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इस भाग में अलग पृष्ठ संलग्न ही जाती है जिससे कि यह प्रलग संकलन के रूप में रखा जा सके।

Separate paging is given to this Part in order that it may be filed
as a separate compilation.

MINISTRY OF COMMERCE

NOTIFICATION

New Delhi, the 10th February 1969

S.O. 565.—Whereas in exercise of the powers conferred by section 6 of the Export (Quality Control and Inspection) Act, 1963 (22 of 1963), the Central Government is of opinion that it is necessary or expedient so to do for the development of the export trade of India, that Cast iron spun pipes should be subject to quality control and inspection prior to export;

And whereas the Central Government has formulated the proposals specified below for the said purpose and has forwarded the same to the Export Inspection Council, as required by sub-rule (2) of rule 11 of the Export (Quality Control and Inspection) Rules, 1964;

Now, therefore, in pursuance of the said sub-rule, the Central Government hereby publishes the said proposals for the information of the public likely to be affected thereby.

2. Notice is hereby given that any person desiring to forward any objections or suggestions with respect to the said proposals may forward the same within thirty days of the date of publication of this notification to the Export Inspection Council, 'World Trade Centre', 14/1-B, Ezra Street (7th floor), Calcutta-1.

PROPOSALS

(1) To notify that Cast iron spun pipes shall be subject to quality control and inspection prior to export;

(2) To specify the type of quality control and inspection in accordance with the draft Export of Cast iron spun pipes (Quality Control and Inspection) Rules.

1969, set out in Annexure I to this notification as the type of quality control and inspection which would be applied to such Cast iron spun pipes.

(3) To recognise the specifications as declared by the exporter to be the agreed specifications of the export contract subject to the minimum specifications set out in Annexure II to this notification as the standard specifications for Cast iron spun pipes.

(4) To prohibit the export, in the course of international trade of such cast iron spun pipes unless the same are accompanied by a certificate issued by any of the Export Inspection Agencies established under section 7 of the Export (Quality Control and Inspection) Act, 1963 (22 of 1963), to the effect that the consignment of cast iron spun pipes satisfies the conditions relating to quality control and inspection and is export-worthy.

2. Nothing in this notification shall apply to the export by land, sea or air of samples of cast iron spun pipes to prospective buyers.

3. "Cast iron spun pipes" means centrifugally cast (spun) iron pipes, manufactured in metal or sand moulds.

ANNEXURE I

Draft rules proposed to be made under section 17 of the Export (Quality Control and Inspection) Act, 1963 (22 of 1963)

1. **Short title and commencement.**—These rules may be called the Export of Cast iron spun pipes (Quality Control and Inspection) Rules, 1969.

(2) They shall come into force on the

2. **Definitions.**—In these rules, unless the context otherwise requires—

(1) 'Act' means the Export (Quality Control and Inspection) Act, 1963 (22 of 1963).

(2) 'Agency' means any of the Export Inspection Agencies established at Cochin, Madras, Calcutta, Bombay and Delhi under section 7 of the Export (Quality Control and Inspection) Act, 1963 (22 of 1963).

(3) 'cast iron spun pipes' means centrifugally cast (spun) iron pipes manufactured in metal or sand moulds.

3. **Quality Control.**—(1) The quality control of the cast iron spun pipes shall be ensured by effecting the following controls at different stages of manufacture together with the levels of control as given in the Table as annexed hereto.

(i) **Bought out materials control.**—(a) Purchase specifications shall be laid down by the manufacturer incorporating the properties of materials to be used.

(b) The accepted consignments shall be either, accompanied by a supplier's test/inspection certificate corroborating the requirements of the purchase specification, in which case occasional checks shall be conducted by the purchaser for a particular supplier to verify the correctness of the aforesaid test/inspection certificates, or the purchased materials shall be regularly inspected/tested either in a laboratory within the factory or in an outside laboratory.

(c) The sampling for inspection/test to be carried out shall be based on ~~subsequent~~ investigation.

(d) After the inspection/test is carried out, systematic methods shall be adopted in segregating the accepted and rejected materials separately and in the disposal of rejected materials.

(e) After the inspection or test is carried out, the results shall be conveyed to the process control department for an effective control of the process.

(f) Records in respect of controls exercised shall be regularly and systematically maintained.

(ii) **Process control.**—(a) Detailed process specifications shall be laid down by the manufacturer for different processes of manufacture.

(b) Equipment/instrumentation facilities shall be adequate to control the processes as laid down in the process specifications.

(c) Adequate records shall be maintained to verify the controls exercised during the process.

(iii) *Product control.*—(a) The manufacturer shall have adequate testing facilities to test the product as per the specification recognised under section 6 of the Export (Quality and Inspection) Act, 1963 (22 of 1963).

(b) Sampling for testing shall be based on a recorded investigation.

(c) Adequate records in respect of tests carried out shall be regularly and systematically maintained.

(iv) *Preservation control.*—(a) A detailed specification shall be laid down by the manufacturer to safeguard the product from adverse effects of weather conditions.

(b) The product shall be well preserved both during storage and during transit.

(v) *Packing control.*—A packing specification safeguarding against adverse effects of transit shall be laid down with a view to ensure safe arrival of the goods at the destination.

(2) *Inspection.*—The inspection of cast iron spun pipes intended for export shall be carried out with a view to see that the abovementioned controls have been exercised at the relevant levels satisfactorily and that the cast iron spun pipes conform to the standard specifications applicable to it.

4. Procedure of Inspection.—(1) The exporter intending to export a consignment of cast iron spun pipes shall give intimation in writing to the Agency and submit along with such intimation a declaration that the consignment of cast iron spun pipes intended for export has been manufactured by exercising quality control measures as provided under rule 3 and that consignment conforms to the requirements of the specifications recognised for this purpose.

(2) The exporter shall also furnish to the agency the identification marks applied on the consignment.

(3) Every intimation and declaration under sub-rule (1) shall reach the office of the agency not less than ten days prior to the despatch of the consignment from the premises of the manufacturer.

(4) On receipt of the intimation and declaration under sub-rules (1) and (2) the Agency on satisfying itself that during the process of manufacture adequate quality control as provided under rule 3 has been exercised and the instructions, if any, issued by the Export Inspection Council in this regard have been observed and after further such inspection/testing considered necessary to ensure conformity of the consignment to the specification recognised shall, within three days, issue a certificate that the consignment satisfies the conditions relating to quality control and inspection and is export-worthy.

5. Place of Inspection.—Inspection under these rules shall be carried out at the premises of the manufacturer only.

6. Inspection fee.—Subject to a minimum of fifty rupees for each consignment, a fee at the rate of twenty paise for every hundred rupee of f.o.b. value of each such consignment shall be paid by the exporter to the Agency as inspection fee under these rules.

7. Appeal.—(1) Any person aggrieved by the refusal of the inspection agency to issue a certificate under sub-rule (4) of rule 4 may, within ten days of the receipt of the communication of such refusal by him, prefer an appeal to a Panel of Experts, consisting of not less than three persons as may be appointed for the purpose by the Central Government.

(2) The quorum for the panel shall be three.

(3) The decision of the said panel on such appeal shall be final.

TABLE
Clause 3 of the Rules)

Requirement	Reference	No. of samples to be tested	Lot size	Remarks
1. Manufacture	Standard specification recognised for the purpose		Each and every pipe	
2. Straightness	—do—		—do—	
3. Dimensions	—do—		—do—	
4. Weight	—do—		—do—	
5. Hydraulic test	—do—		—do—	
6. Ring Test	—do—	One	Production of 4 hours	In case of failure 2 more samples shall be tested. Should either of these addl. test pieces fail, the lot shall be rejected.
7. Hardness test	—do—	—do—	—do—	—do—
8. Coating test	—do—	one	Production of 8 hours	

ANNEXURE II
Specification for Cast Iron Spun Pipes

1. Manufacture.

1.1. The metal used for the manufacture of pipes shall be of good quality cast iron. The pipes shall be free of warping, shrinkage or any other defect. The pipes shall be such that they could be cut, drilled or machined.

2. Tolerances on Dimensions and weight

2.1. The following tolerances shall apply on dimensions.

Item	Tolerance in mm
(i) External diameter of barrel	$\pm \frac{1}{3} (9 + 0.003 D)$
(ii) Internal diameter of socket	$\pm \frac{1}{2} (9 + 0.003 D)$
(iii) Depth of socket	$\pm \frac{1}{3} (9 + 0.003 D)$ $\pm \frac{1}{4} (9 + 0.003 D)$
(iv) Wall thickness	± 5 for pipes of nominal dia. of upto and including 600 mm, ± 10 for pipes of over 600 mm.
(v) Flange thickness	\pm Unlimited. ($1 + 0.05e$)
(vi) Length	$\pm (2 + 0.05 b)$ ± 25 (± 10 for flanged pipes).

Note :—In clause

2.1 (i) to (vi) D denotes the nominal diameter of pipes in mm;
e denotes the thickness of wall in mm.
b denotes the thickness of flange in mm.

2.2 A tolerance of $\pm 5\%$ shall be permissible on weight.

3. Permissible deviation from a straight line.

3.1. The pipes shall be straight, when rolled along two gantries separated by approximately two-thirds the length of the pipe to be checked, the maximum deviation 'fm' in millimeters should not be greater than 1.25 times the length 'L' in meters of this pipe, thus $fm \leq 1.25L$.

4. Hydraulic test.

4.1. A pressure of 15 kg/cm² shall be maintained for 15 seconds and when struck with a 700 g hammer, the pipes shall not show any sign of leakage, sweating or any other defect. This test shall be conducted before coating the pipes.

5. Ring test.

5.1. Rings of about 25 mm width shall be cut from the pipes and tested on a suitable machine and the modulus of rupture shall not be less than 40 kg/mm².

The ring shall be supported on two knife edges diametrically opposed and the load shall be applied from inside of these points. The formula for modulus of rupture will be—

$$R = \frac{3P}{TT} (ED - e)$$

where

TT be²

R=modulus of rupture of the ring in kg/mm²;

P=breaking load in kg;

ED=external diameter of the ring in mm;

e=thickness of the wall of the ring in mm;

b=breadth of the ring in mm:

6. Hardness.

6.1. The hardness of the external unmachined surface of the pipes shall not exceed the Brinell Hardness No. 210. Pipes may be subjected to suitable heat treatment to ensure this requirement.

7. Coating.

7.1. Except when otherwise agreed to between the buyer and the seller, all pipes shall be coated externally and internally with the same material, the pipes being heated prior to total immersion in a bath containing a uniformly heated composition having tar or other suitable base. The coating material shall set rapidly with good adherence and shall not scale off.

7.2. Where the coating material has a tar or similar base, it shall be smooth and tenacious and hard enough not to flow when exposed to a temperature of 70°C but not so brittle at a temperature of 0°C as to chip off when scribed lightly with a pen knife.

7.3. When the pipes are to be used for conveying potable water the inside coating shall not contain any constituent soluble in such water or any ingredient which could impart any taste or odour whatsoever to the potable water after sterilization and suitable washing.

[No. 60(70) Exp. Insp/68.]

A. C. BANERJEE, Jt. Secy.

